

Date: Monday, 3/27/2006 10:00:46 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: PLUG		
Job Number	: 26364					
Estimate Number	: 10178					
P.O. Number	: N/A			Part Number	: D25941	
This Issue	: 3/27/2006		S.O. No.	: N/A		
Prsht Rev.	: NC			Drawing Number	: D2594 REV B1	
First Issue	: 3/23/2006		Type	: MACHINED PARTS		
Previous Run	: 25593			Project Number	: N/A	
Written By	: See Comments Below			Drawing Revision	: B1	
Checked & Approved By	: 06.03.21			Material	: N/A	
Comment	: Est D 02.08.22 Make in Cobra KJ			Due Date	: 4/10/2006	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	M6061T6R0625	6061-T6 Round Bar .625"	
		Comment: Qty.: 0.0547 f(s)/Unit Total : 27.3525 f(s) Material: 5052-H32 (QQ-A-225/7) or 6061-T6 (QQ-A-225/8) 1100-0 (QQ-A-225/1) Ø0.625" Rod (M5052H32R0.625) or (M6061T6R0.625)	
		Batch M19712	
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
		Comment: HARDINGE CNC LATHE SMALL 1-Make as per Dwg D2594-1 and Folio FA262. 2-Break all sharp edges 0.010 max.	
		Deburr. M.F. 06/07/05	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
		Comment: HAND FINISHING RESOURCE #1 Acid etch and alodine as per QSI 005 4.1	
		SAD 06:07:08	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/08/09
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
								

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0 POWDER COATING

POWDER COATING



SC 06/07/28 100
VSC 06/08/03 407



507

Comment: POWDER COATING

Powder Coat Gloss White (Ref: 4.3.5.1) per Dart QSI 005 4.3 (only larger dia. section necessary)

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



507

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DC 06/08/06

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP 15

DC 06/08/06

507

9.0 DC

DOCUMENT CONTROL



507

Comment: DOCUMENT CONTROL

Inspection Level 21

DC 06/08/06

Job Completion



16.08.06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	26364
Description: Plug	Part Number:	D2594-1
Inspection Dwg: D2594	Rev: B1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	MJS	Audited by:	JML	Prototype Approval:	N/A
Date:	06/06/20	Date:	06/06/20	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.21	New Issue	KJ/RF	JF

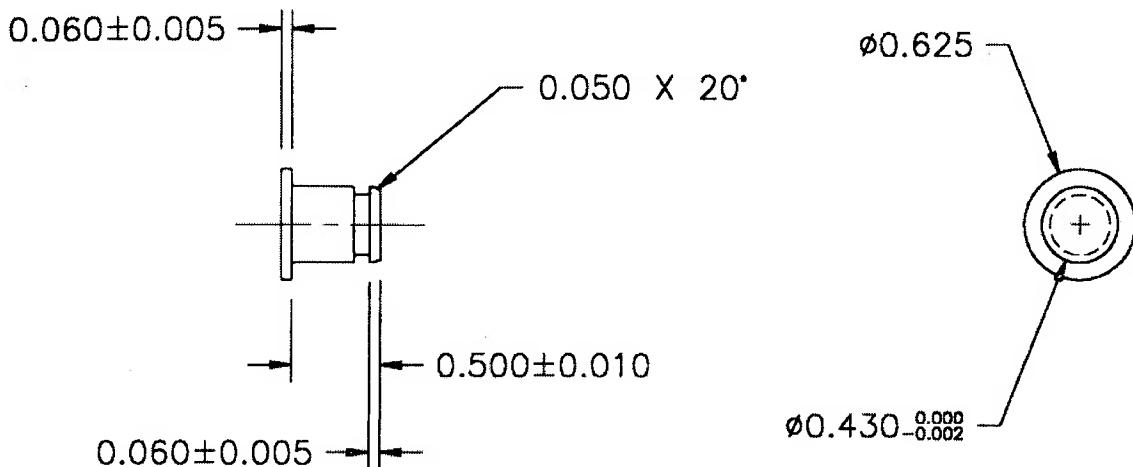


COPYRIGHT
DART

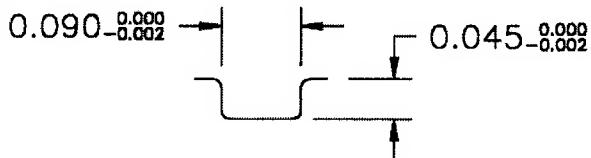
DESIGN <i>DIDY</i>	DRAWN BY <i>DIDY</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BW</i>	APPROVED <i>DIDY</i>	DRAWING NO. D2594	REV. B SHEET 1 OF 1
DATE 96:09:16		TITLE PLUG	SCALE 1:1
B	97:03:15	ADD GROOVE AND O-RING	
B1	RF 02.08.26	ADD Powder coat, QSI 018, & QQ-A SPES.	

D2594-1 PLUG:

RELEASER
97/03/27 DS



GROOVE DETAIL (SCALE 5:1)



TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

BREAK ALL SHARP CORNERS 0.010 MAX

MATERIAL: 5052-H32 OR 6061-T6 OR 1100-O

FINISH: ACID ETCH, ALODINE

Powder coat white (REF. 43.S.1) PER QSI 005 4.3

BI

PER QQ-A-225/7 (5052)
OR QQ-A-225/8 (6061)
OR QQ-A-225/1 (1100)
OR QQ-A-200/3 (6061)

BI

D2594-3 O-RING: 5/16 ID, 7/16 OD, 1/16 WIDTH
(PARKER 2-011)

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 26364

D2594 PLUG ASSEMBLY INCLUDES: {1} D2594-1 PLUG
{1} D2594-3 O-RING